

Work Order ID 163169

163169

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Thursday, June 22, 2017 10:17:43 AM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
 Start Date: 6/22/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/5/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUN 22 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	record fwd angle: <u>89.9</u>								
	Photocopy blue file and type labels per PPP D350-636-012 CHG 007								

17-06-27
 DAS 28 9-89
 AUG 11 2017

B163169RH

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16",
then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN
first side. Repeat process on second side. ✓***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP
WHEN DRILLING FIRST SIDE*** ✓Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig
DT8150 & DT8863A for second side only DT8863B for first side (detail K) ✓4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND
ANGLE. ✓6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297". ✓

7- Open up holes of Detail J to 0.297" (total of 2 holes per side) ✓

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

B158774

17-06-28
DT

BE170703

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Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: **M136920**

9- Grind welds flush as per Dwg D2750

7861707-03

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Quality Control

Memo

0.00

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Quality Control

Memo

0.02

DAS
38
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JUL 04 2017

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JUL 04 2017

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Required Date: 7/5/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.70				1	17-07-11		
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.01				1	17-07-11		
Quality Control									

DAS
18
9-00

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Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.93

1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 137127

exp. date: 17-09-26

15h

****ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)****

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: MB7633

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

17-07-18
DL17-07-11
DL

7 BE17-07-13

17-07-13
DL

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.02							
Quality Control	***VERIFY C'BOARD IS GOOD***								

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JUL 21 2017DAS
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JUL 21 2017

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.41

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

(X1)

0

20170718

BEB

200

Spray Painting per QSI005 4.2

0.00

200

SprayPaint

Memo

0.43

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 1371952- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 138058

1

DAS
41
9-89

AUG 02 2017

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 x d 11 17/08/01

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Reference:

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Assemble as per dwg	0.00							
230	HandFinishing								
Hand Finish	Memo	1.11							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M137446</u>								
	EXP DATE: <u>18103</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M135477</u>								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>M133690</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.02							
Quality Control									

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AUG 10 2017

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Customer:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.01

Packaging

(**DAS**
6
9-89 **AUG 10 2017** **DAS**
27
9-89

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.03

Quality Control

DAS
28
9-89 **AUG 11 2017**

270

Identify as per dwg & Stock Location: _____

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012
Location: **FG072**

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27
9-89 **AUG 11 2017**

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Item ID: D350-636-012

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.10

Quality Control

DAS
21
9-89

AUG 1 1 2017

DAS
21
9-89

AUG 1 1 2017

Picklist Print

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Parent Item: D350-636-012

D350-636-012

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I02.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	5.0000	1	1			
D2600-3-BENT-RH									**			17-06-22	
Extrusion Bent RH												DL	
				<u>Location</u>				<u>Loc Qty</u>					
				LG002				5				1	
				158774				5					
D2744		Manufactured	No			110	Each	20.0000	1	1			
D2744									**			BE1707-03	
Cap													
				<u>Location</u>				<u>Loc Qty</u>					
				LG001				20					
				159371				10					
				161732				10					
D2739		Manufactured	No			160	Each	11.0000	1	1			
D2739									**			17-07-11	
350 I Beam												DL	
				<u>Location</u>				<u>Loc Qty</u>					
				LG002				11					
				159936				3					
				161380				8					

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

172.0000

8

8

D2743

Crossbolt Spacer

**

BB17-07-12

Location

Loc Qty

Loc Code

LG001

172

159308

62

160400

110

D3490-3

Manufactured No

160

Each

83.0000

4

4

D3490-3

Cross Bolt Spacer

**

BB170712

Location

Loc Qty

Loc Code

LG001

83

160393

83

D3490-1

Manufactured No

160

Each

95.0000

4

4

D3490-1

Cross Bolt Spacer

**

BB170712

Location

Loc Qty

Loc Code

LG001

95

160394

95

D3631-1

Manufactured No

230

Each

159.0000

8

8

D3631-1

Washer

**

xl 17108103

Location

Loc Qty

Loc Code

FP001

159

159502

59

160124

100

xe

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

20.0000

1

1

D3791-1

Wearpad

**

JLL 17108103

LocationLoc QtyLoc Code

FP002

20

158753

10

X1

161928

10

D3793-3

Manufactured No

230

Each

29.0000

1

1

D3793-3

Wearplate Aft

**

JLL 17108103

LocationLoc QtyLoc Code

FP002

29

159397

4

159871

25

X1

MS21043-6

Purchased No

230

Each

72.0000

4

4

MS21043-6

NUT

**

JLL 17108103

LocationLoc QtyLoc Code

FG

20

103693

20

M137963

X4

FP001

12

m135470

2

m137361

10

ST302

40

m137479

40

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

15.0000

1

1

D3794-1

Gasket Fwd

**

ell 17/08/03

Location

Loc Qty

Loc Code

FP001

15

142770

1

150417

2

159376

12

x1

NAS1611-010

Purchased No

230

Each

203.0000

8

8

NAS1611-010

O-RING

**

ell 17/08/07

Location

Loc Qty

Loc Code

FP001

203

m134955

7

m135603

8

m136182

4

m136836

84

m137587

100

M137963

x4

x4

D2741

Manufactured No

250

Each

47.0000

1

1

D2741

Replacement Blade

**

**DAS
27
9-89**

7/18/10

Location

Loc Qty

Loc Code

FG

10

131616

10

ST538

37

132981

14

158915

23

1

**DAS
28
9-89**

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

403.0000

4

4

***NAS1515H3I ***

Washer

**

all 12/08/07

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

359

m127831

20

m134508

3

m135600

2

m136263

4

m137361

330

ST266

4

XJ

m130726

4

NAS1611-013

Purchased

No

230

Each

174.0000

8

8

NAS1611-013

O-Ring

**

all 12/08/07

Location

Loc Qty

Loc Code

FP001

174

m137333

174

X8

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

147.0000

4

4

AN3C6A

Bolt

**

all 17/08/02

Location

Loc Qty

Loc Code

FG

10

1138040

XL

122416

10

FP001

21

m136295

4

m136781

17

OVER002

96

m137361

96

ST350

20

m128704

18

m132767

2

NAS1149C0832R

Purchased

No

230

Each

49.0000

1

1

NAS1149C0832R

Washer

**

all 17/08/02

Location

Loc Qty

Loc Code

FP001

49

m135536

49

XL

D3536-25

Manufactured

No

230

Each

27.0000

1

1

D3536-25

Gasket Center

**

all 17/08/02

Location

Loc Qty

Loc Code

FG

3

95328

3

FP001

24

146747

2

159368

4

162506

18

XL

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Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

13.0000

1

1

D3794-3

Gasket Aft

**

all 17/08/03

Location

Loc Qty

Loc Code

FP001

13

B163320

x1

159369

12

159924

1

AN3C5A

Purchased

No

230

Each

928.0000

34

34

AN3C5A

Bolt

**

all 17/08/03

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

657

M137361

657

134

OVER002

200

M137710

200

ST350

66

M135442

66

Picklist Print

Thursday, June 22, 2017 10:17:47 AM

Page 8

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

162.0000

3

3

D3537-1

Wearpad

**

all 17/08/03

Location

Loc Qty

Loc Code

FG

11

B163518

X3

79833

1

88562

10

FP001

151

141922

7

147593

5

154226

1

159356

38

161530

50

161531

50

D3535-25

Manufactured No

230

Each

18.0000

1

1

D3535-25

Wearplate Center

**

all 17/08/03

Location

Loc Qty

Loc Code

FG

1

148669

1

FP002

17

159879

7

161915

10

X1

D3492-3

Manufactured No

230

Each

218.0000

8

8

D3492-3

Plug

**

all 17/08/03

Location

Loc Qty

Loc Code

FP001

218

B162347

X8

159296

136

162347

82

Thursday, June 22, 2017 10:17:47 AM

Shop Packet Print

Page 8

Picklist Print

Thursday, June 22, 2017 10:17:47 AM

Page 9

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

4,974.000

38

38

NAS1149C0332R

**

all 12/08/03

WASHER

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

1137951

x39

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

996

m137381

996

D3488-042

Manufactured

No

230

Each

3.0000

1

1

D3488-042

**

all 12/08/02

Blade Fitting RH

Location

Loc Qty

Loc Code

FP001

3

158787

3

B162374

x1

Picklist Print

Thursday, June 22, 2017 10:17:47 AM

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

2,629.000

38

38

AI S4-1032-225

**

Rivnut

Location

Loc Qty

Loc Code

FG

25

M134975

20

M135998

5

FP001

2204

M135603

40

M135920

38

M135998

2115

M136265

11

ST556

400

M136579

400

x38

D3492-1

Manufactured

No

230

Each

144.0000

8

8

D3492-1

**

Plug

Location

Loc Qty

Loc Code

FP001

144

158389

1

159298

63

161306

80

x8

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

**

Wearplate Fwd

Location

Loc Qty

Loc Code

FP002

26

159358

4

159874

22

x1

Picklist Print

Page 11

Thursday, June 22, 2017 10:17:47 AM

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

124.0000

1

1

AN8C35A

**

Bolt

see 12/08/03

Location

Loc Qty

Loc Code

FG

3

121275

3

FP001

121

m133336

1

m134130

1

m134133

7

m137203

112

x1

MS21083C8

Purchased

No

230

Each

63.0000

1

1

MS21083C8

**

Nut

see 12/08/03

Location

Loc Qty

Loc Code

FP001

18

m137412

18

x1

ST297

45

m137361

25

m137820

20

D2745

Manufactured

No

230

Each

182.0000

8

8

D2745

**

Bushing

see 12/08/03

Location

Loc Qty

Loc Code

FP001

182

159297

82

161760

100

x2

Thursday, June 22, 2017 10:17:47 AM

Shop Packet Print

Page 11

Picklist Print

Thursday, June 22, 2017 10:17:47 AM

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

AN6C44A

Bolt

**

ell nlogloz

Location

Loc Qty

Loc Code

FP001

78

m132556

78

over009

250

m137055

250

ST333

48

m136658

48

D3532-1

Manufactured

No

250

Each

45.0000

2

2

D3532-1

Spacer

**

DAS 6 9-89

ANG 7/1/2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST038

45

159312

45

MS21083C8

Purchased

No

250

Each

63.0000

2

2

MS21083C8

Nut

**

DAS 6 9-89

ANG 10/1/2017

DAS 27 9-89

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

Picklist Print

Thursday, June 22, 2017 10:17:47 AM

Page 13

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

264.0000

2

2

NAS1149D0863.J

Washer

**

DAS
6
9-89

AUG 10 2017
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

46

125484

46

ST260a

100

125635

100

ST263

118

125268

118

7

D3493-1

Manufactured

No

250

Each

39.0000

2

2

D3493-1

Washer

**

DAS
6
9-89

AUG 10 2017
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST037

29

159305

9

161754

20

163466x1

1

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

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Shop Packet Print

Page 13

Picklist Print

Thursday, June 22, 2017 10:17:47 AM

Page 14

Work Order ID: 163169

163169

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

302.0000

2

2

AN8C21A

**

Bolt

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

over004

217

m137162

217

ST332

81

m136262

1

m137162

80

DAS
28
9-89

DAS
6
9-89

AUG 10 2017

DAS
27
9-89

2

Thursday, June 22, 2017 10:17:47 AM

Shop Packet Print

Page 14

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1	1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163169 MJS
1706-22

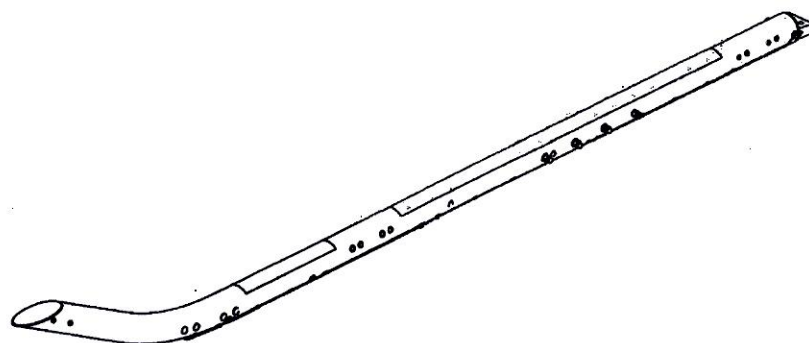
RELEASED
2013-08-13
WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 REPLACES QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2739 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

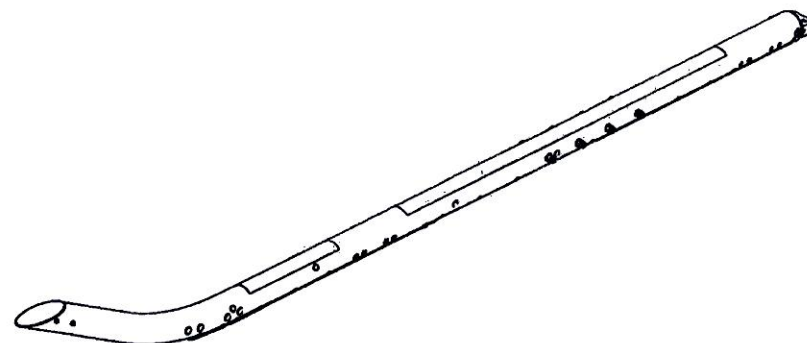
DART AEROSPACE USA, INC.

KENT, WA
DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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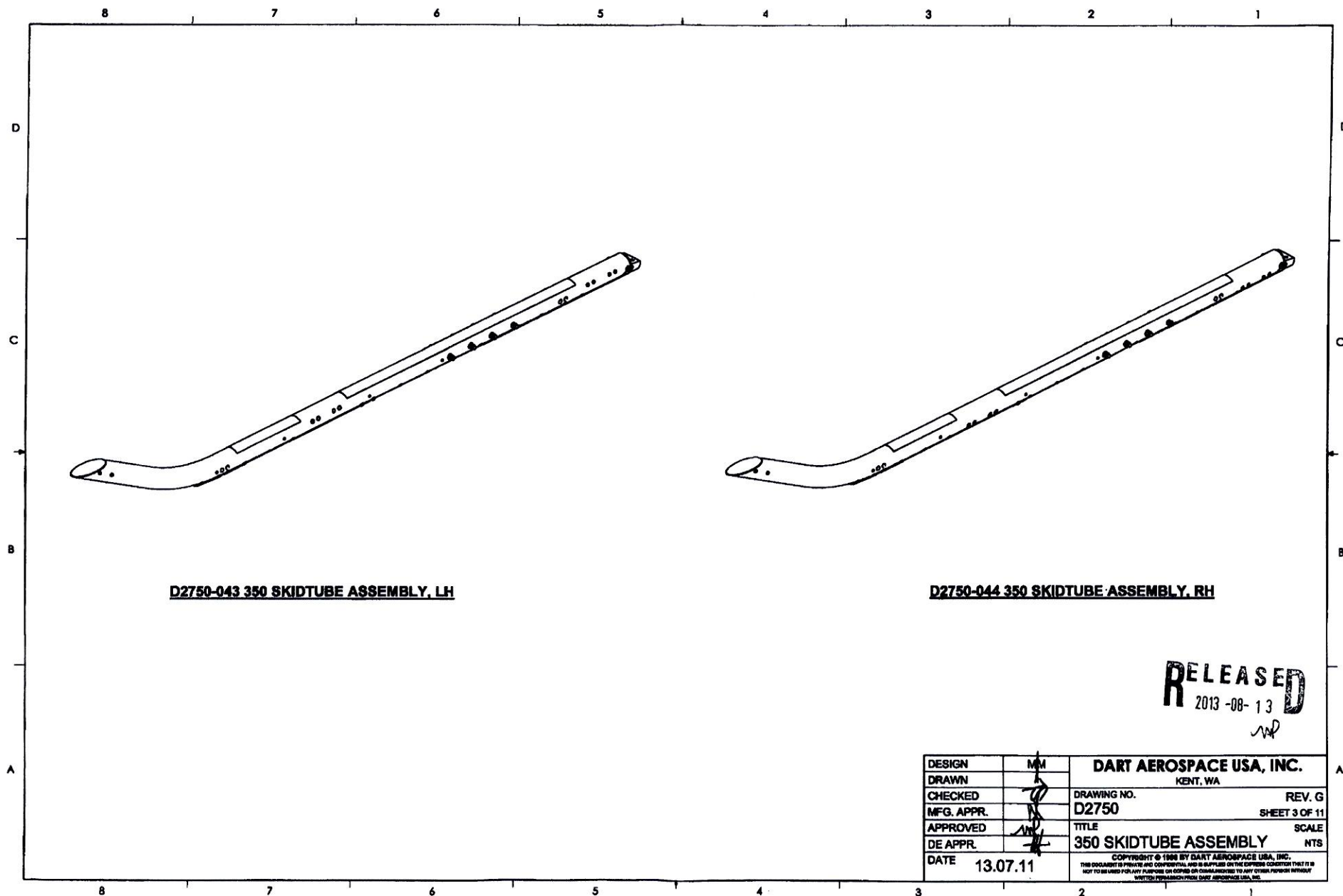
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MD

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 2 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



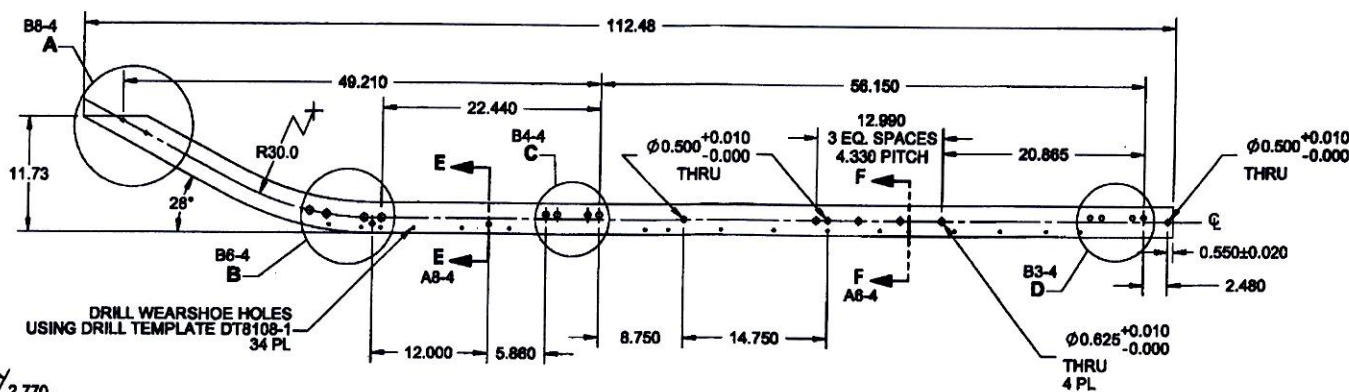
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

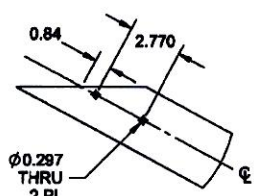
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2013-08-13
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DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	
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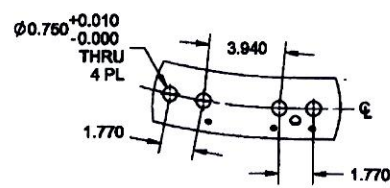
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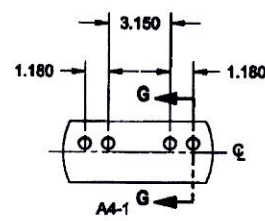
D2750-1 LH SKIDTUBE



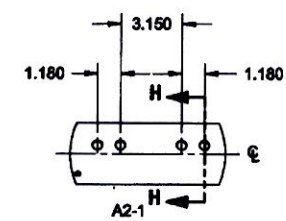
DETAIL A
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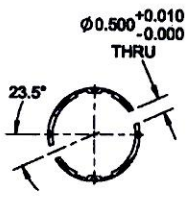
DETAIL B
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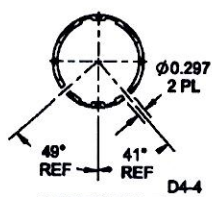
DETAIL C
SCALE 2X



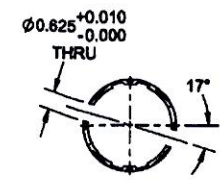
DETAIL D
SCALE 2X



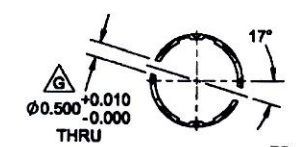
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

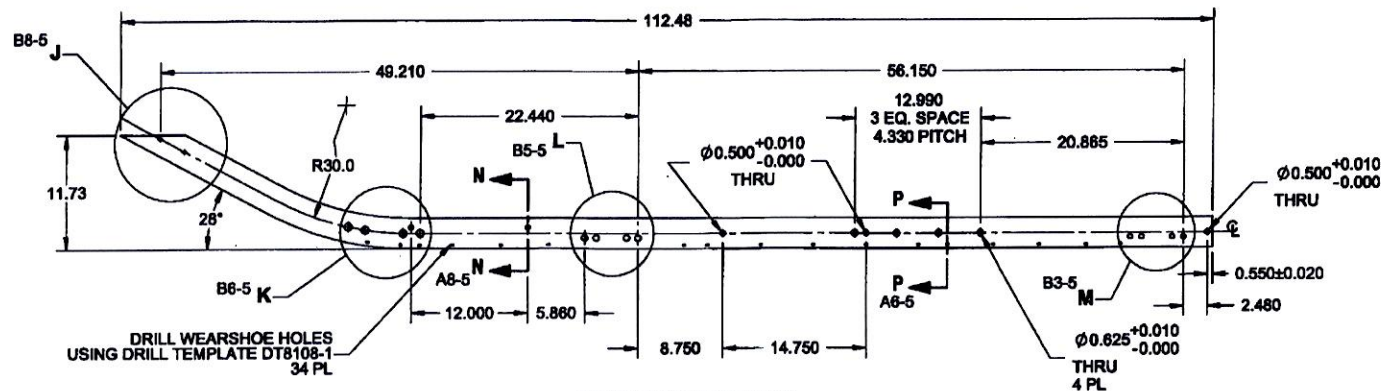


SECTION H-H
SCALE 3X, 4 PL

RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROVIDED AS IS AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

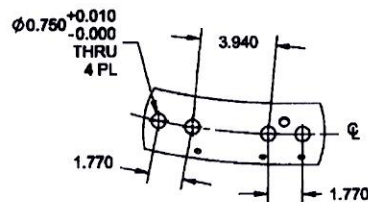
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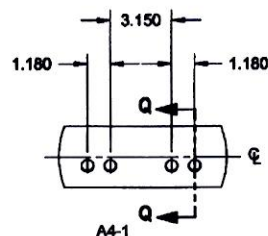
D2750-2 RH SKIDTUBE



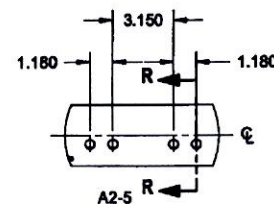
DETAIL J
D8-5
SCALE 2X



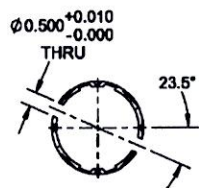
DETAIL K
C7-5
SCALE 2X



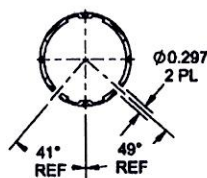
DETAIL L
D8-5
SCALE 2X



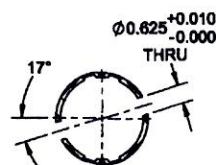
DETAIL M
C3-5
SCALE 2X



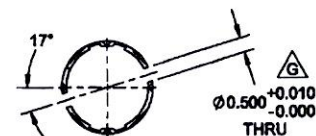
SECTION N-N
C6-5
SCALE 3X, 2 PL



SECTION P-P
C4-5
SCALE 3X, 17 PL



SECTION Q-Q
B5-5
SCALE 3X, 4 PL

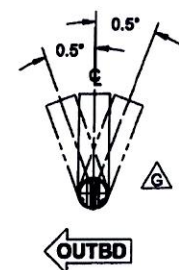
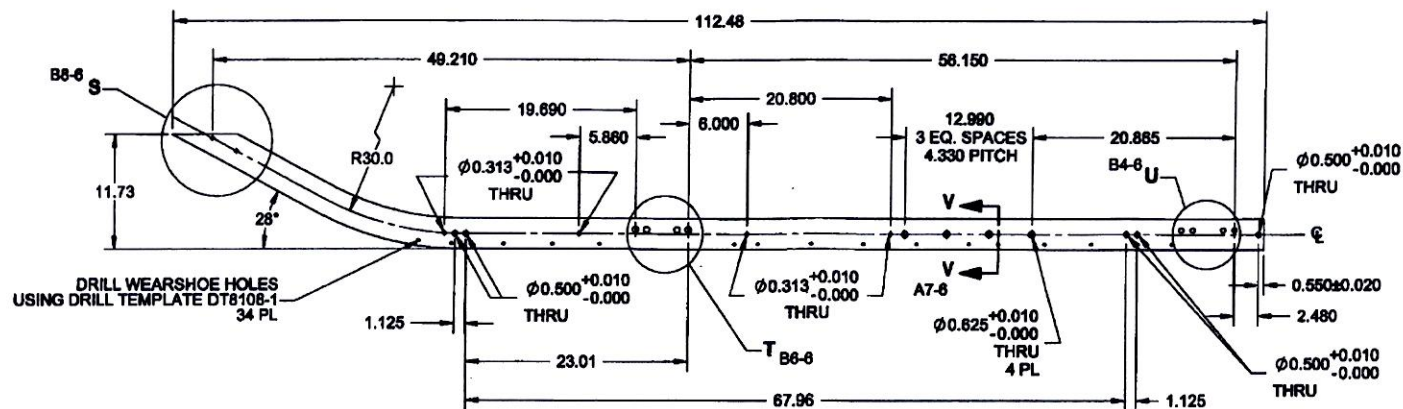


SECTION R-R
B3-5
SCALE 3X, 4 PL

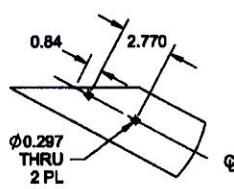
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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 5 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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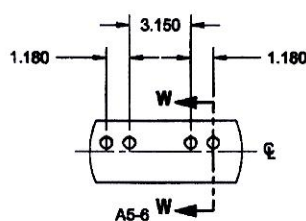
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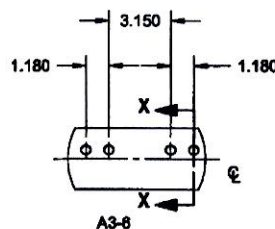
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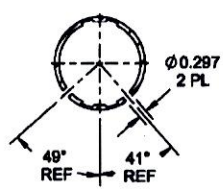
DETAIL S
SCALE 2X



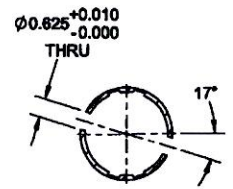
DETAIL T
SCALE 2X



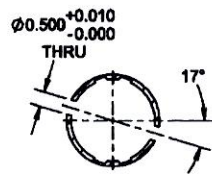
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

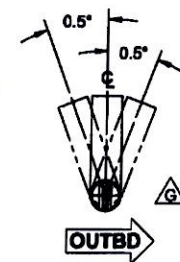
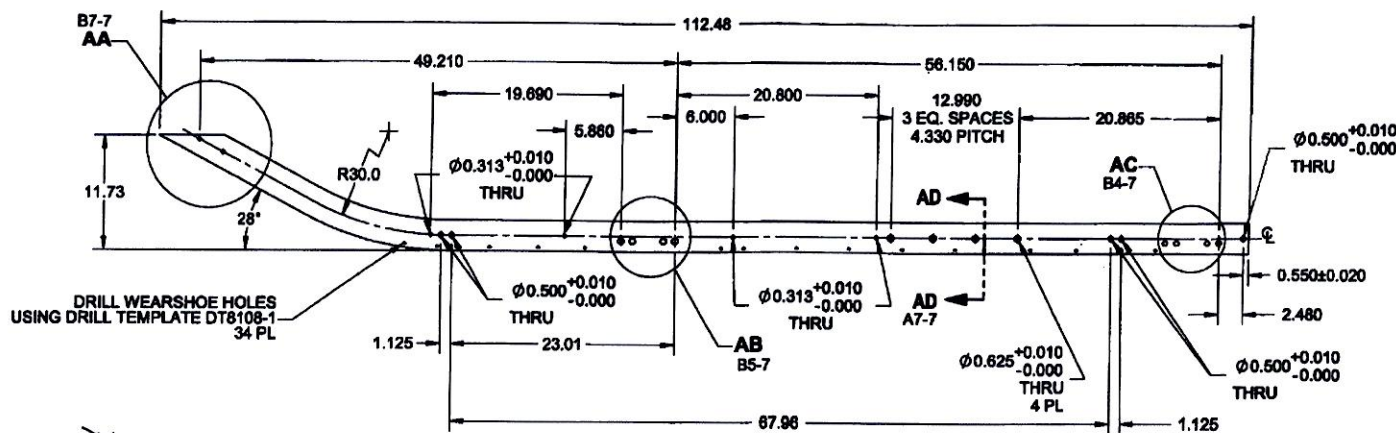


SECTION X-X
SCALE 3X, 4 PL

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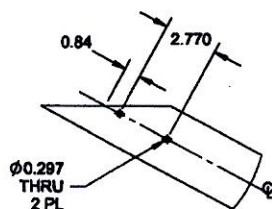
DESIGN	MM	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 8 OF 11
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8 7 6 5 4 3 2 1

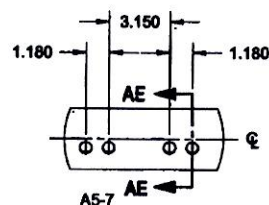


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

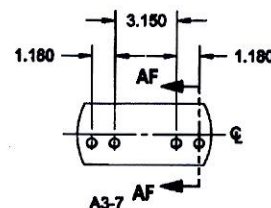
D2750-4 RH SKIDTUBE



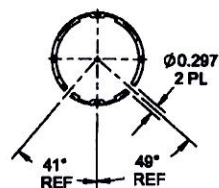
DETAIL AA
SCALE 2X



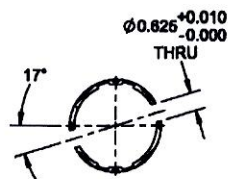
DETAIL AB
SCALE 2X



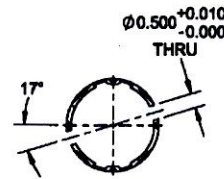
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



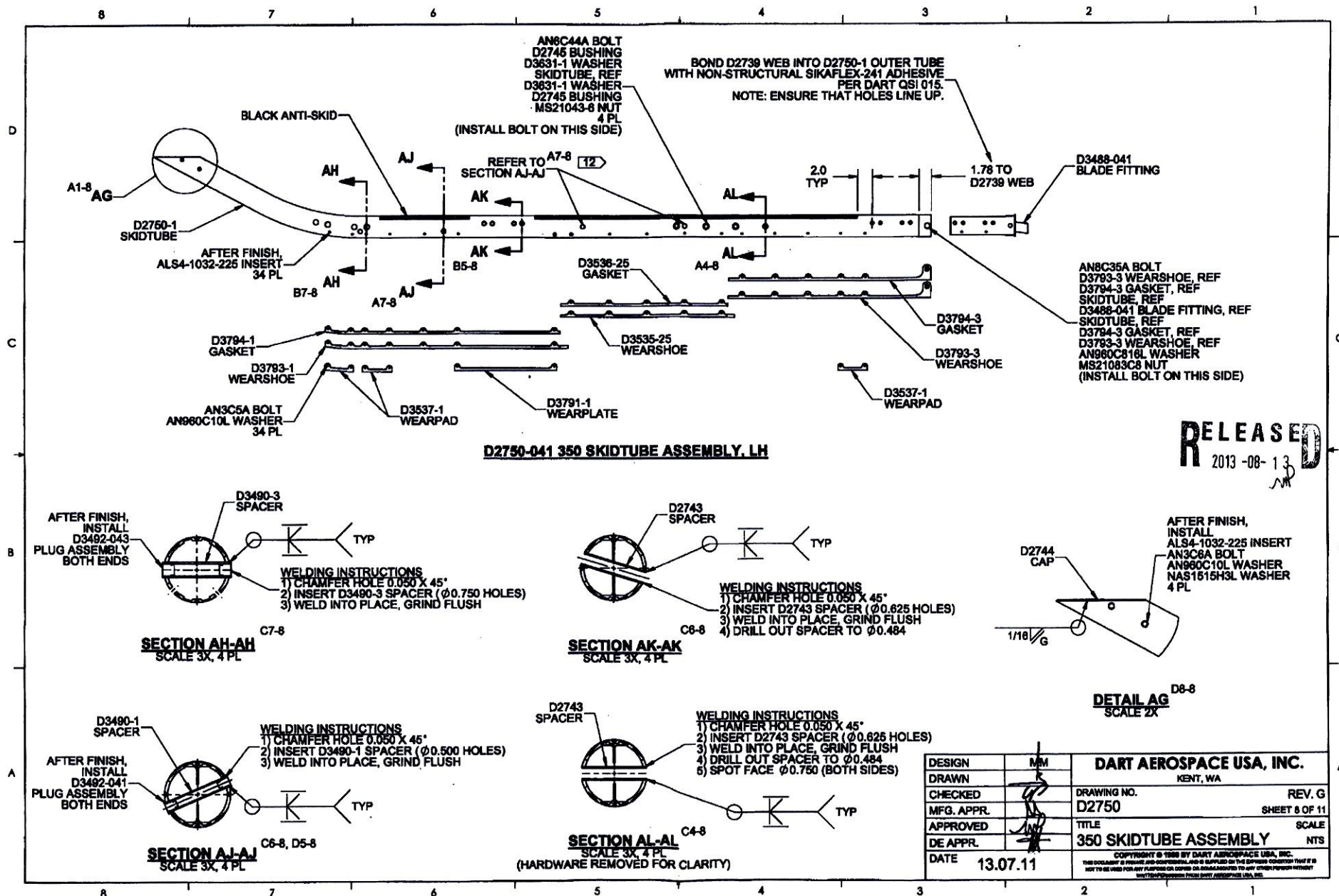
SECTION AE-AE
SCALE 3X, 4 PL



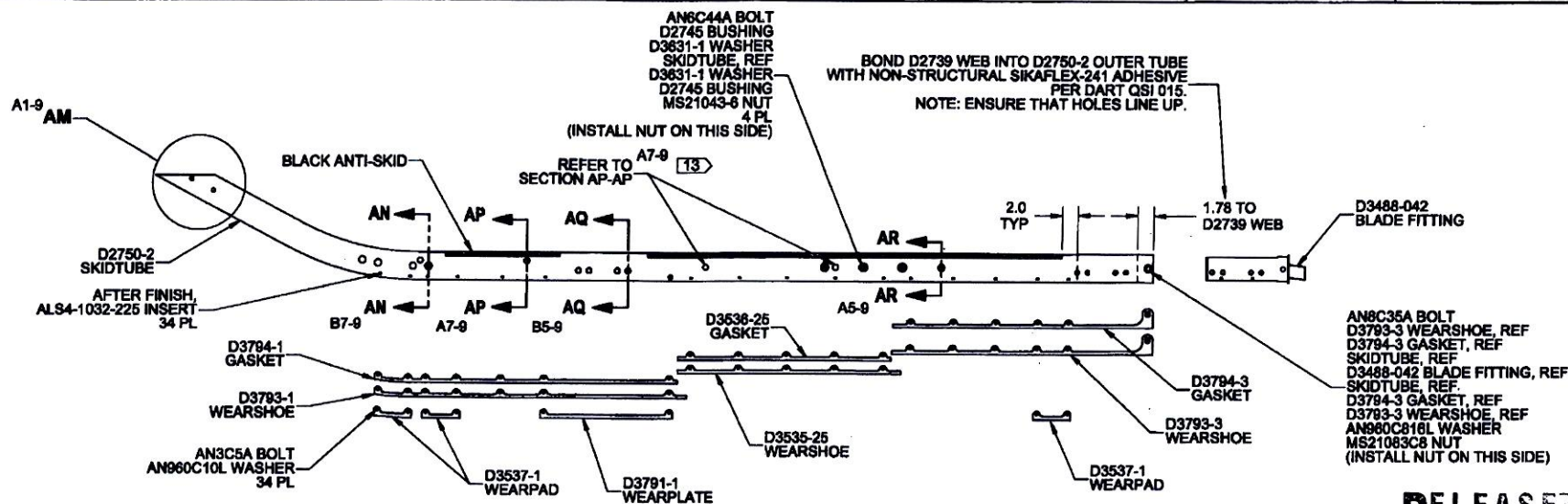
SECTION AF-AF
SCALE 3X, 4 PL

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APPROVED		TITLE	SCALE
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2013-08-13
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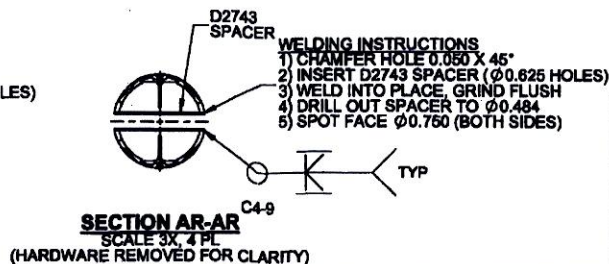
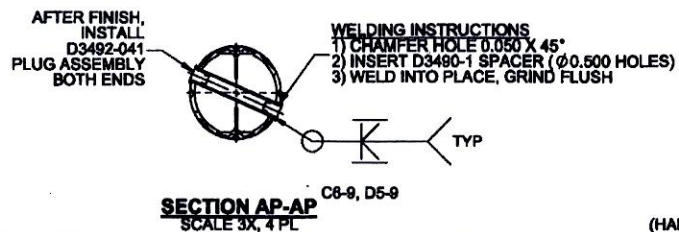
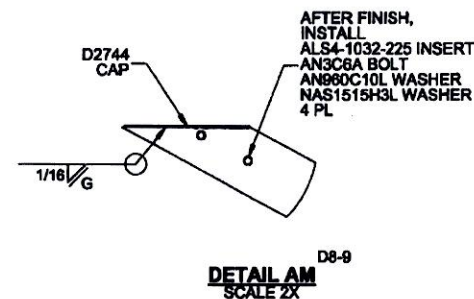
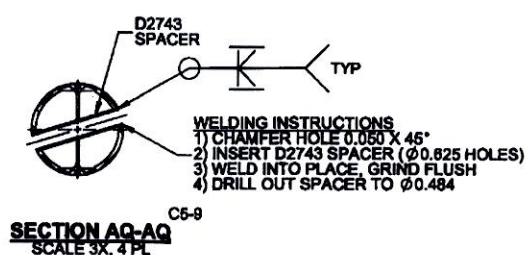
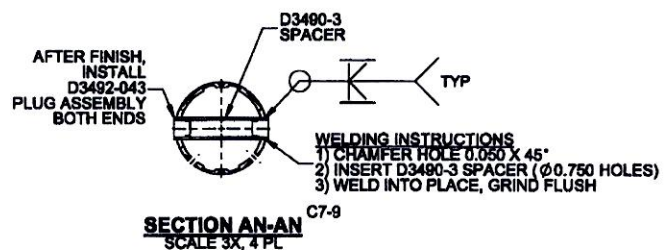


8 7 6 5 4 3 2 1



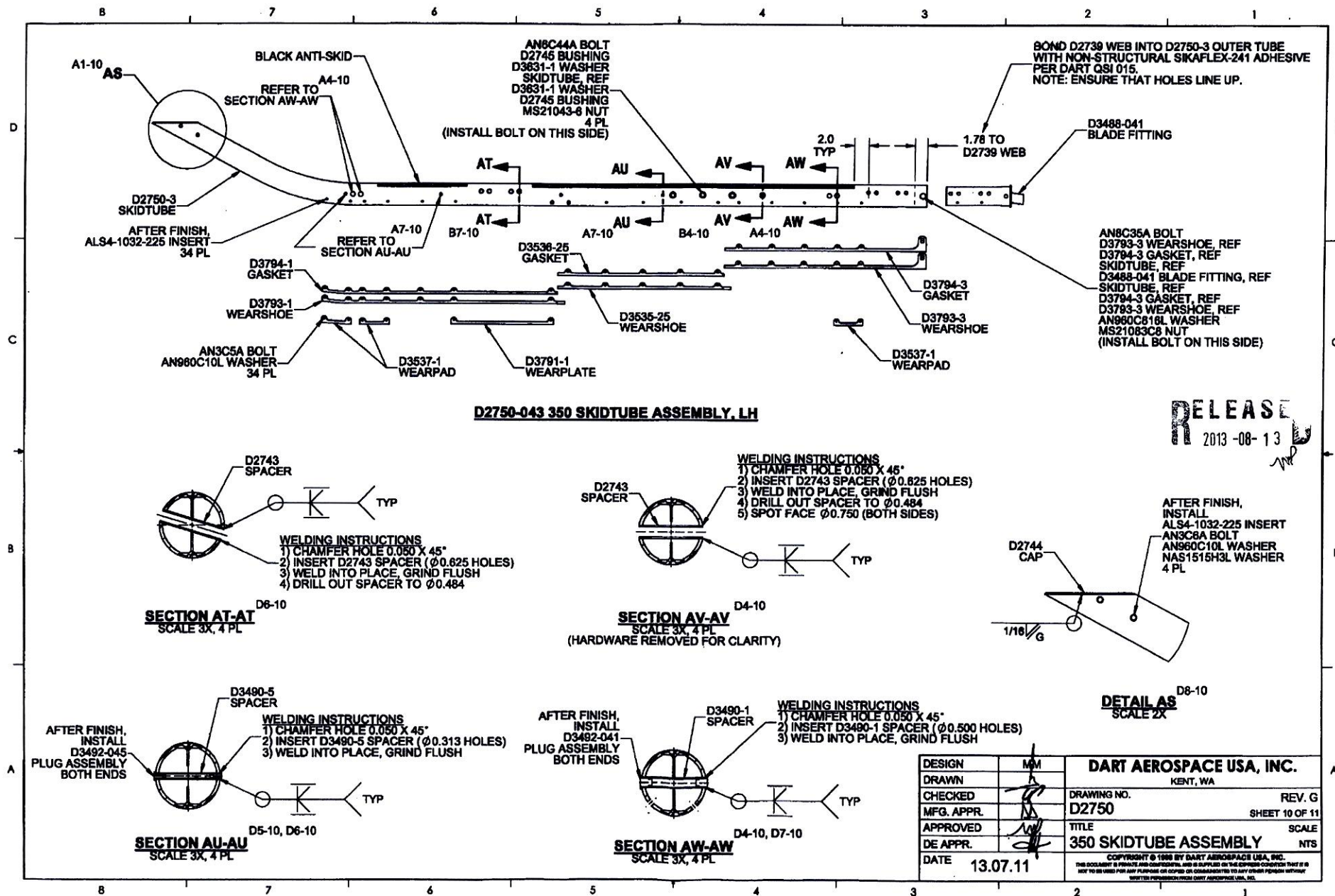
D2750-042 350 SKIDTUBE ASSEMBLY, RH

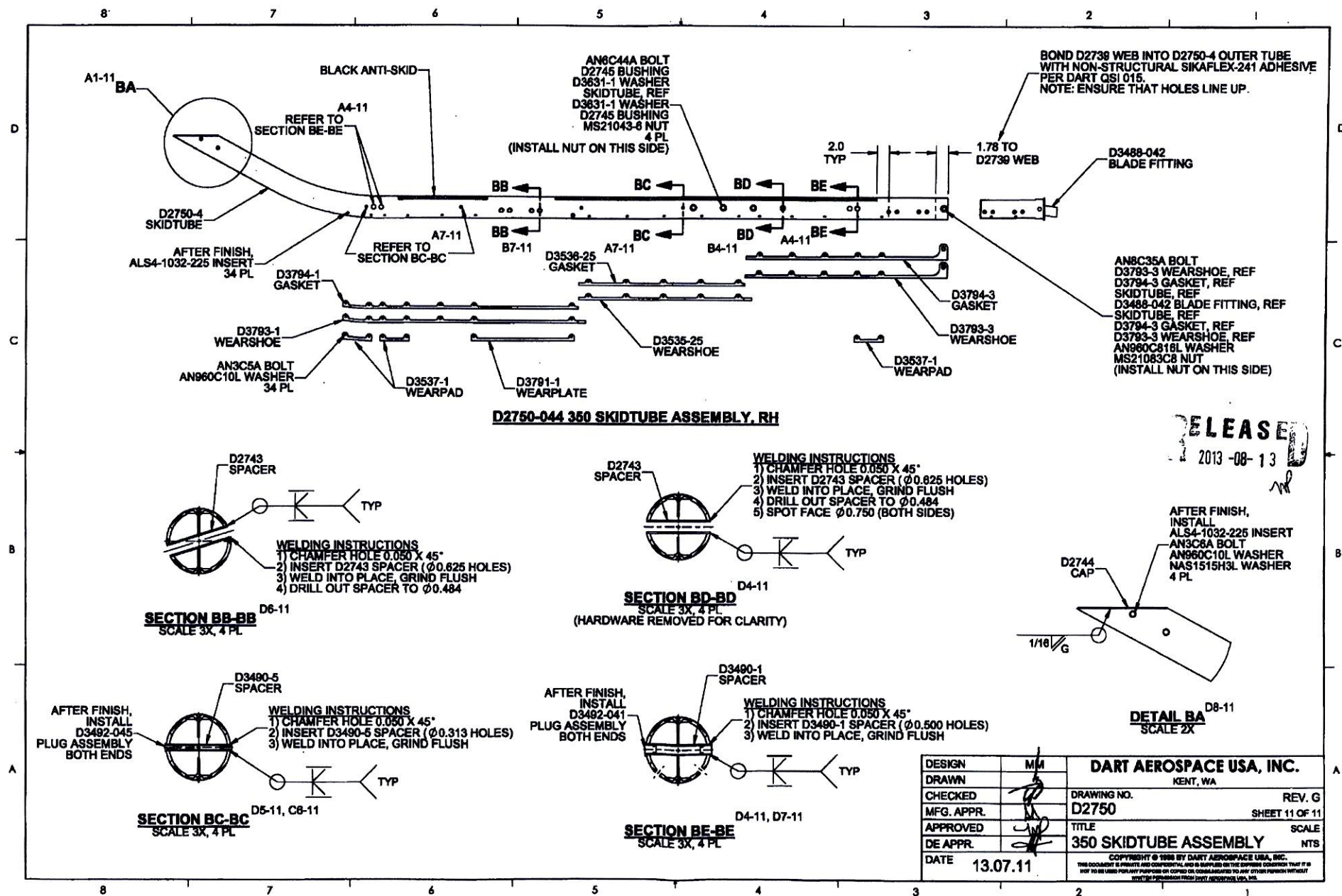
RELEASED
2013-08-13



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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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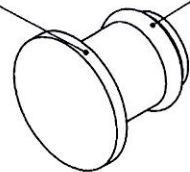
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D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

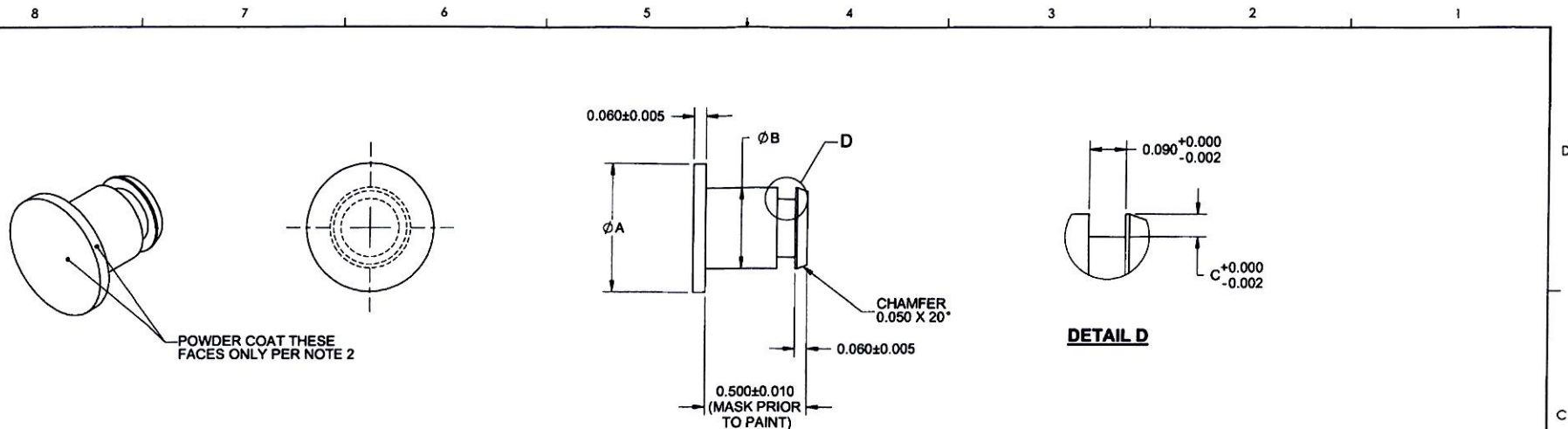
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
11 2013-11-13

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	11	D3492	SHEET 1 OF 2
APPROVED	11	TITLE	SCALE
DE APPR.	11	PLUG	NTS
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D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D3492	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	PLUG	4:1
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RELEASED
- 2013-11-13

Work Order ID 163169

Tuesday, June 22, 2017 10:17:43 AM

Accept

N900040100

Setup

Stop *NS2*

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan:

Date: JUN 22 2017

Tooling:

Date:

SPC (Y/N):

Date:

QC:

Date:

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D2750-042

G

D3492

E

DAS
6
9-89

0.00

100

Document Control

DOCUMENT CONTROL

0.00

100

DC

Doc. Control -USB or Paperwork

Memo

record fwd angle: 29.9

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
5
9-89

AUG 11 2017